

Work Order ID 57108

March 22, 2010 10:09:32 AM



Page 1

Item ID: D3910-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug

Start Date: 22/03/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 20.00

Customer:

Reference:

Just 10.03.22

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3910

A

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut to 1.450" Long

DJP 10/03/22

20 *φ*

110

0.00



HAAS I

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA865 AND DWG

FOLIO REV: A

DWG REV: B

DEBURR

MNF 10/03/24

20 *φ*

Work Order ID 57108

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Page 2

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Run Start



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Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	MWF 10/03/24			20	0		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SA	10/03/27		20	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	MF	10/03/29		(X20)	0		

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Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation

Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

START: 7:00AM

⇒ Jul 10/03/30

Memo

Temp: 326°F

0.00

FIN: 7:30AM

X20 Ø

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

BK 10-3-30

(20) /

170



Packaging

Packaging

Identify as per dwg & Stock Location: 507

0.00

Memo

0.00

CL 10/11/01

(X20)

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/06

ME

10-4-5

Picklist Print

March 22, 2010 10:09:31 AM

Page 1

Work Order ID: 57108

Parent Item: D3910-3

Parent Item Name: Crosstube Lug

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

Start Date: 22/03/2010

Required Date: 26/03/2010

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	566.3488	2.7368			



Lug Extrusion



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

566.3488432

43722

173.462806

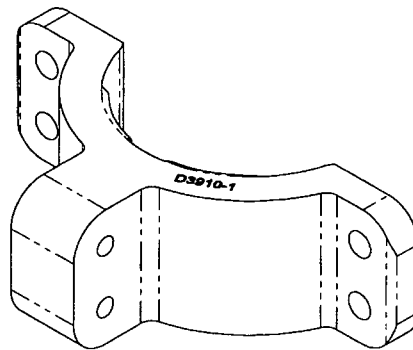
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5.7731

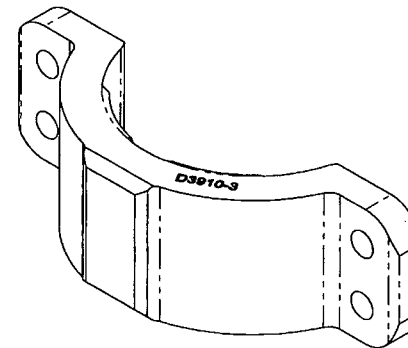
45800

387.112937

2.73685 mL 10/03/20



D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 \pm 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 \pm 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

RELEASED
2010-03-22
MD

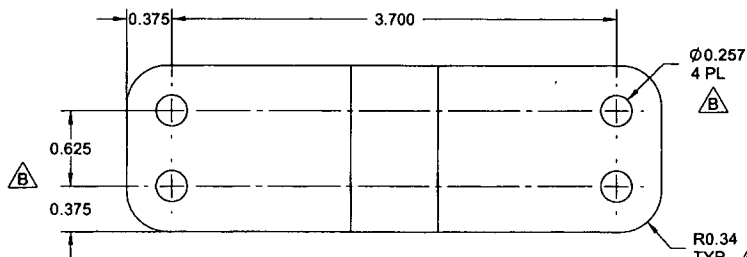
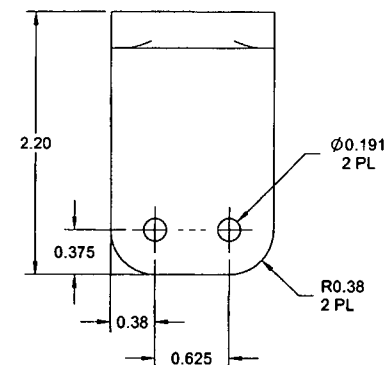
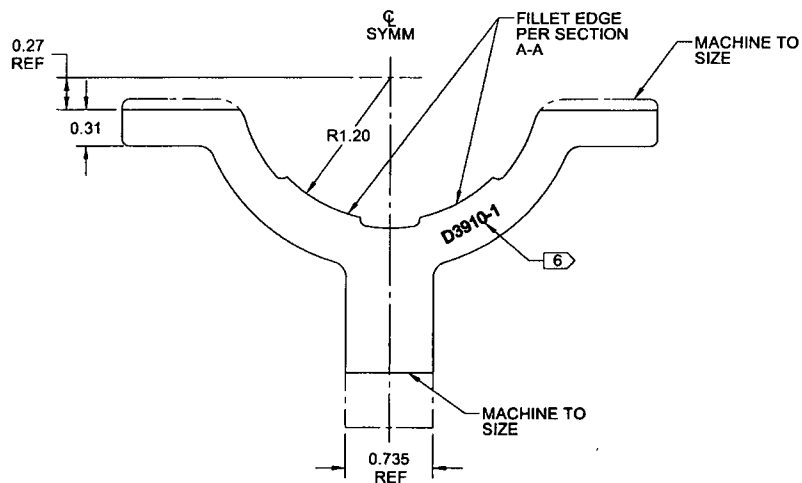
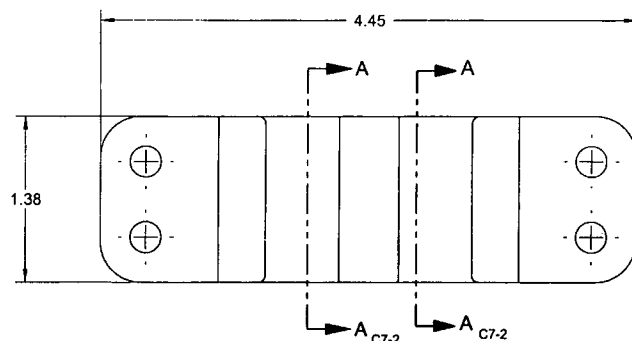
57108

B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D350-807-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED		DRAWING NO.	D3910	REV. B
MFG. APPR.				SHEET 1 OF 3
APPROVED		TITLE	X-TUBE LUG (350)	SCALE
DE APPR.				NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		



ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A
C4-2
C5-2



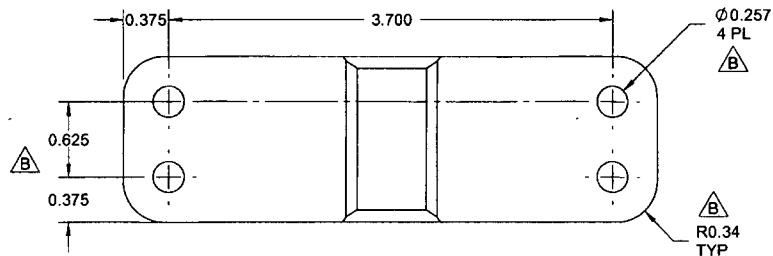
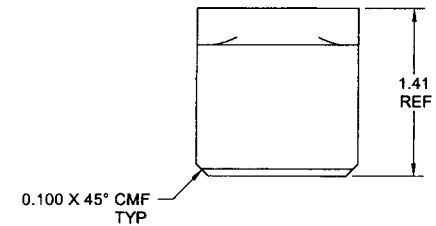
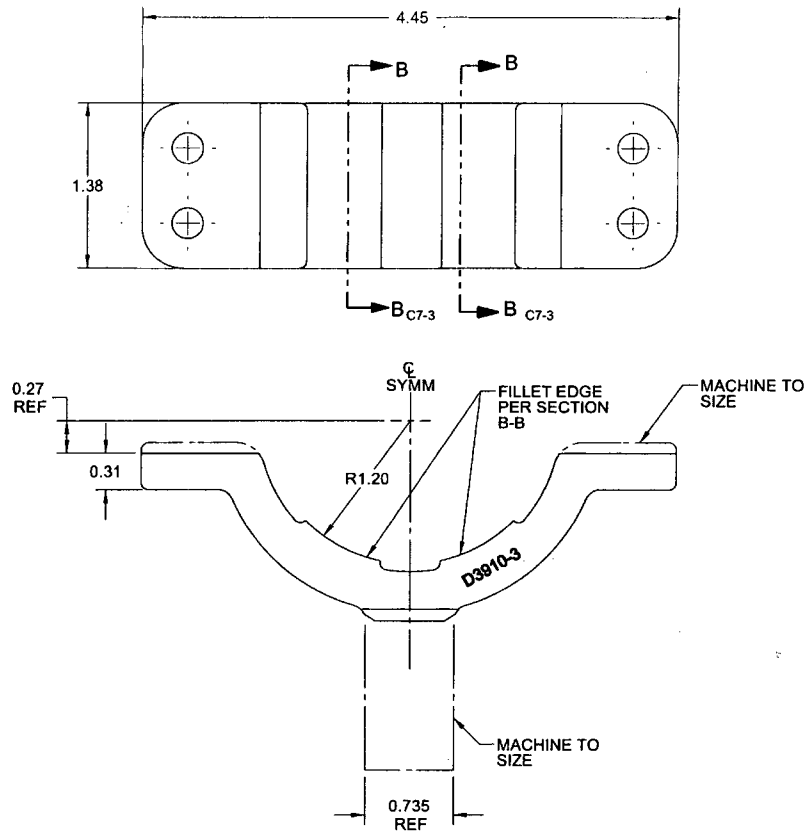
D3910-1 X-TUBE LUG

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2010-03-22
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ROUND EDGE
 R0.06 MIN - 0.10 MAX
 2 PL
SECTION B-B
 C4-3
 C5-3



D3910-3 X-TUBE LUG

DESIGN	AJS	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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